

Date: Friday, 9/21/2007 1:01:24 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT WEB
Job Number : 34794	
Estimate Number : 10791	
P.O. Number : N/A	Part Number : D3282041
This Issue : 9/21/2007 S.O. No. : N/A	Drawing Number : D3282 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : MA Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 33878	Material : N/A
Written By : <u>AWM 07/09/24</u>	Due Date : 10/5/2007 Qty: 12 Um: Each
Checked & Approved By : <u>AWM 07/09/24</u>	
Comment : Est Rev B 05.09.23 Procedure change KJ/JLM	

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	D2792130	EXTRUSION
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Comment: Qty: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1 D2792-130

Extrusion

B33518

AWM 07/09/25

Identify as D3282-1

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

AWM 07/09/25

(12)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Debur

J.E./J.L./S.A. 07/10/16

(Pro) →

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.E./J.L./S.A. 07/10/16

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.E./J.L./S.A. 07/10/16

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/15	3	- 1 web is scrapped, operator forgot to raise "Z" after installing parallels, end-mill machined bottom of web R.C. Humman error	 07/10/30	- scrap + replace = Replace.	J.L. 07/10/15 	Er 07/10/16	 07/10/30	Er 07/10/15
07/10/16	4 5	one web has three holes so drilled while drilling. R.C. Drill hit the support block.	CP 07.10.17 per QSI 0472	Part are acceptable Enlarged holes will have no noticeable effect on strength of web. ON NEUTRAL AXIS	SD 07/10/16 	Er 07/10/17	CP 07.10.17 per QSI 0472	Er 07/10/16

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

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Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM 07-10-18



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 7-10-18 (12)

8.0

D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

B 3482a

(24) 7-10-18

9.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total : 684.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

M104 936

(684) 7-10-18 (12)

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3 M104 929 7-10-18

(12)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Es 09/10/19 (12)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

7-10-22 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:01:24 PM
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 34794

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U *9/18/07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34794
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282 Rev: C		Page 1 of 1	

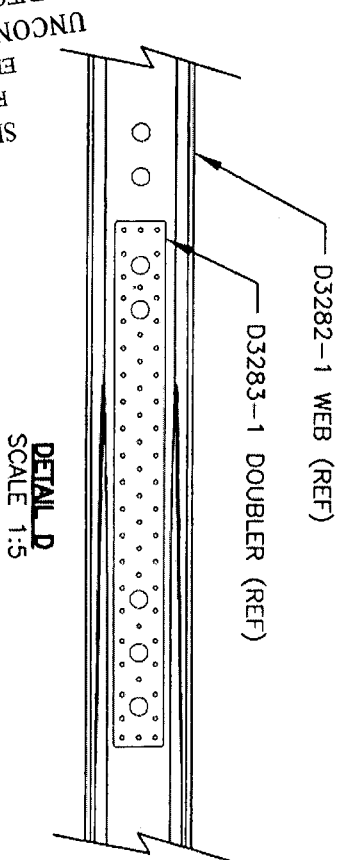
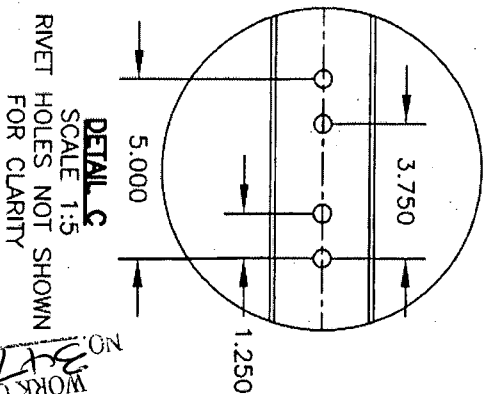
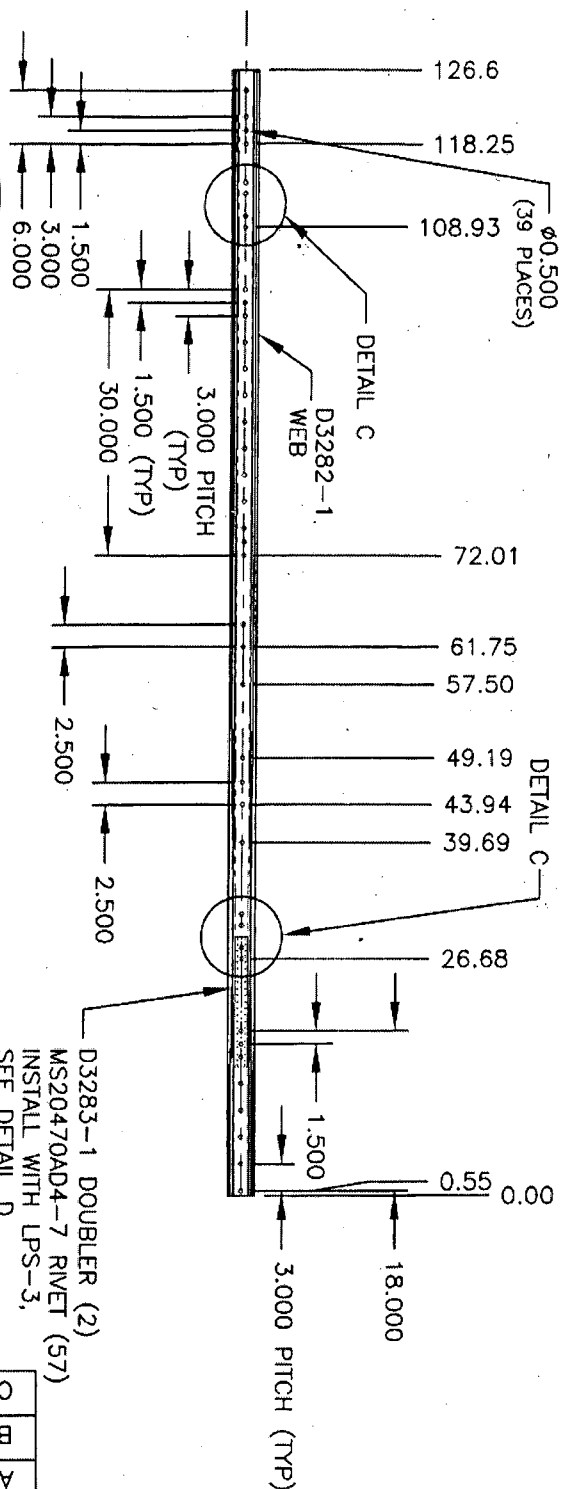
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.6	✓			
1.500	+/-0.010	1.500	✓			
3.000	+/-0.010	3.000	✓			
6.000	+/-0.010	6.000	✓			
1.250	+/-0.010	1.250	✓			
30.000	+/-0.010	30.000	✓			
1.500	+/-0.010	1.500	✓			
72.01	+/-0.030	72.01	✓			
61.75	+/-0.030	61.75	✓			
57.50	+/-0.030	57.50	✓			
49.19	+/-0.030	49.19	✓			
43.94	+/-0.030	43.94	✓			
39.69	+/-0.030	39.69	✓			
26.68	+/-0.030	26.68	✓			
0.55	+/-0.030	.55	✓			
1.970	+/-0.010	1.969	✓			
2.38	+/-0.030	2.385	✓			
0.05	+/-0.030	.055	✓			

Measured by:	J.L.	Audited by:	EG	Prototype Approval:	N/A
Date:	04/10/13	Date:	07.10.14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	





D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION $\frac{1}{2}$
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

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 WITHOUT NOTICE
 WORK ORDER
 NO. 34794
 EXTRUSION

RELEASED

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C	SHEET 1 OF 2	SCALE	DATE	05.08.09	TITLE	FLOAT WEB, 206L/407	1:20
CHECKED		APPROVED		D3282									
A	04.05.05	NEW ISSUE											
B	05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS											
C	05.08.09	REMOVE D3390-1, NOW MACHINED											



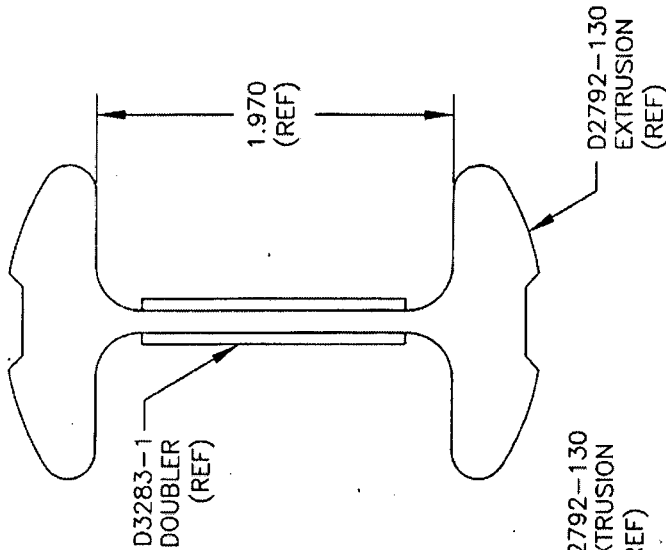


DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3282	REV. C SHEET 2 OF 2
DATE 05.08.09	TITLE FLOAT WEB, 206L/407		SCALE 1:20

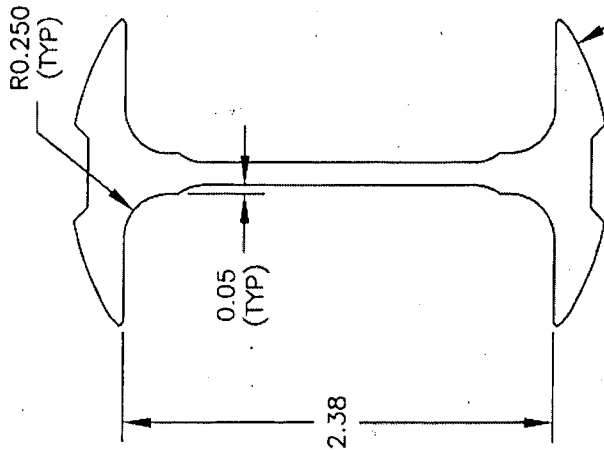
RELEASED

05-09-12 [Signature]

SECTION B-B

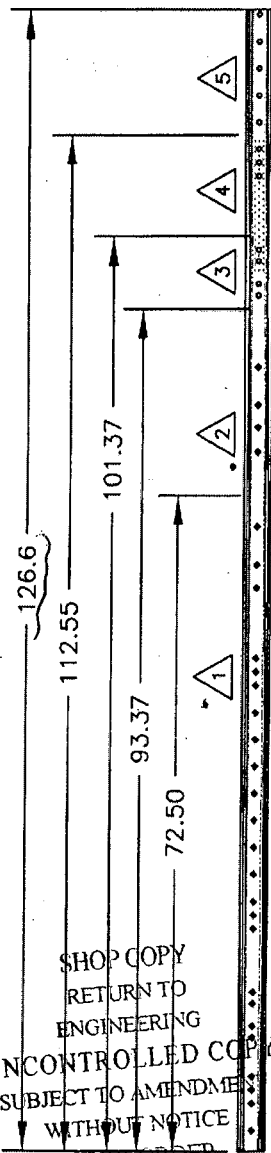


SECTION A-A



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,
SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



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WORK ORDER
NO. 34794

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